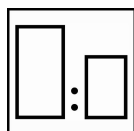


Autobase Classic

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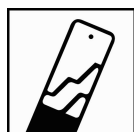
Description

Autobase Classic provides excellent coverage, metallic control and sprayability when used to duplicate OEM solid, metallic and pearl color effects. Autobase Classic must be used in conjunction with a Sikkens clearcoat in order to provide protection from the environment. Autobase Classic is the superior choice to achieve optimal color match.



100 Autobase Classic

50 Plus Reducer



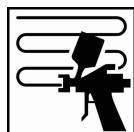
Use Sikkens measuring stick

1 Black



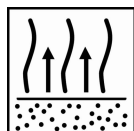
Spray gun set-up:
1.2-1.4 mm

Application pressure:
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



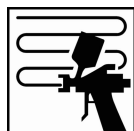
Application metallic colors:
Full coat – intermediate coat – mist coat

Application solid colors:
2 x 1 coat



Between coats
3-5 minutes at 20°C

Before clearcoat application
15 minutes at 20°C



Clearcoat application
See clearcoat T.D.S.



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

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Description

Autobase Classic provides excellent coverage, metallic control and sprayability when used to duplicate OEM solid, metallic and pearl color effects. Autobase Classic must be used in conjunction with a Sikkens clearcoat in order to provide protection from the environment. Autobase Classic is the superior choice to achieve optimal color match.

Suitable substrates

Existing finishes.
All current Sikkens preparatory products, with the exception of washprimers

Products and additives

Autobase Classic MM colors

Plus Reducers	Plus Reducer Fast:	spot and panel repairs, temperature range: 15°C-25°C.
	Plus Reducer Medium:	spot and panel repairs and large areas, temperature range: 20°C-30°C.
	Plus Reducer Slow:	larger areas and complete paint jobs, temperature range: 25°C-35°C.
	Plus Reducer Extra Slow:	temperature range: above 35°C.

Basic raw materials

Autobase Classic: Physical drying binders

Surface preparation



Final sanding step P500
○ For detailed surface preparation see TDS S8.06.02



Final sanding step P1000
○ For detailed surface preparation see TDS S8.06.02



Remove contamination using an appropriate cleaner

Autobase Classic

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Mixing



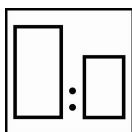
Mixing Machine

Stir MM toners every 4 hours for 15 minutes.



Stir after mixing

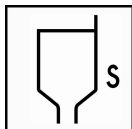
Stir the Autobase Classic MM colors thoroughly directly after mixing the color formula.



100 Autobase Classic
50 Plus Reducer
Use measuring stick 1

Some metallic colors show a higher sensitivity for cloudiness/mottling. Adding 30 additional parts of Plus Reducer will give improved metallic orientation, sprayability and flow.

Viscosity



14-16 seconds DIN cup 4 at 20°C.

Spray gun set-up / application pressure



Spray gun
Gravity feed

Fluid tip – set-up
1.2-1.4 mm

Application pressure
1.7-2.2 bar at the spray gun air inlet
HVLP max 0.6-0.7 bar at the air cap

Pot-life

6 Months at 20°C when stored in a closed can.
4 Hours at 20°C in a closed can, when mixed with hardener.
Stir the ready to spray mixture thoroughly before use.

Application process

Solid colors

Apply 2 single coats or until opacity is achieved. Flash-off between coats until completely matt

Metallic colors

Apply a closed wet coat. Next apply a light wet coat. Flash-off between coats until completely matt.
Next apply a mist coat.

Spot repairs:

Decrease application pressure and apply thin coats until opacity is achieved
Dry until matt before fading out well beyond the edges. In case of metallic colors apply a drop coat if needed.
In the case of well hiding colors, transparency can be increased by adding Z070 RTS to the mixed color.

Allow for a minimum of 15 minutes final flash-off time at 20°C before clearcoat application.

Autobase Classic

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Film thickness

By using the recommended application;	
Solid colors	20-30 microns
Metallic and Pearl colors	15-25 microns

Masking

Autobase Classic can be taped after at least 20 minutes flash-off at 20°C.

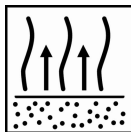
Denibbing

Allow Autobase Classic to flash-off for at least 20 minutes at 20°C.
Then lightly sand the damaged area with P500 free-cut dry or P1000 grit wet sanding paper.
Thoroughly remove sanding residue before continuing Autobase Classic application.

Recoat with

All current Sikkens clearcoats, with the exception of
Autoclear LV Superior
Autoclear UV
Autoclear 2.0

Recoat time



Autobase Classic Solid: 5 hours Autobase Classic Metallic and Pearl: 48 hours

To extend the re-coat time of **solid** colors up to 48 hours, add 10% of Hardener P25.
Stir thoroughly before adding Plus Reducer.

Material usage

By using the recommended application the theoretical material usage is $\pm 10 \text{ m}^2/\text{l}$ RTS mixture.

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure, method and application circumstances

Cleaning of equipment

Sikkens Solvents or solvent borne Guncleaners.

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuation.
Product shelf life data see TDS S9.01.02.

Autobase Classic

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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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